une-04-12 1:28:33 PM Item ID: D350-636-015 Accept *N900040100* Setup Start **Revision ID:** Skidtube STD w/ Training Wearplates, LH Item Name: **Start Date:** Start Qty: 1.00 04/06/2012 Cust Item ID: **Required Date:** 18/06/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: MLJ Date: 12/06/04 Tooling: **Approvals:** Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Qty Qty Number Stamp Code **Draw Nbr Revision Nbr** С. D3492 D4168 Α IIN-D350-636 100 0.00

Document Control

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Photocopy blue file and type labels per PPP D350-636-015 CHG 003

DOCUMENT CONTROL

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W/O:		WORK ORDER CHANGES					
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June-04-12 1:28:33 PM D350-636-015 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube STD w/ Training Wearplates, LH **Start Date:** 04/06/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 18/06/2012 Reg'd Oty: 1.00 **Customer:** Reference: Run **Process Plan:** Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool# Set Up/ Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Oty **Qty** Number Stamp 110 0.00 Skidtubes *110* Skidtubes 0.00 Memo Skidtubes 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168 3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section H-H

> BE 12/06/28 5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as

6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade

fitting, section H-H

per dwg D4168, detail A

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

9-Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side) open holes of detail D section H-H to 0.500" as per dwg D4168

10-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

BE 10/06/28

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Sequence ID/ Work Center II)		m Rod batch: <u>M/ 6</u> flush as per Dwg D4168	Ω_{-} 1	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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NOTE: Date & initial all entries

Resolution:

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Quality Control

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D350-636-015 Item ID: Accept *N900040100* Setup Start Revision ID: Item Name: Skidtube STD w/ Training Wearplates, LH *1* **Start Date:** 04/06/2012 Start Oty: 1.00 Cust Item ID: **Required Date:** 18/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool # Set Up/ Tool ID Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 140 Chemical Conversion Coat per QSI005 4.1 0.00 1 7/6 12-7.16 *140* HandFinish 0.00 Memo Hand Finishing QC3- Inspect Part Finish 150 0.00 5AD 10-07-17 QC

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Item ID: D350-636-015 Accept *N900040100* Start Setup **Revision ID:** Stop Item Name: Skidtube STD w/ Training Wearplates, LH **Start Date:** 04/06/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 18/06/2012 Req'd Oty: 1.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code Oty Qty Number Stamp 160 0.00 Skidtubes *160* Skidtubes 0.00 Memo Skidtubes 1-Open up holes of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" (4 per side) section AJ-AJ Open wearplate holes to size as per dwg (4 holes per sides), section CG-CG 4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015 12-7-17 A/R Sikaflex-291 batch: (717) 30 exp. date: / 3-3-14 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & OSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: BER-07-18 9- At section AJ-AJ drill out x-bolt spacer to 0.404

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June-04-12 1:28:33 PM Item ID: D350-636-015 Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube STD w/ Training Wearplates, LH **Start Date:** 04/06/2012 Start Qty: 1.00 **Cust Item ID: Customer:** Reference: - -- -----Run Approvals: **Process Plan:** Date: Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty **Qty** Number Stamp 180 QC5- Inspect part completeness to step on W/O 0.00 *120* OC Memo Quality Control 190 Pressure Wash per QSI005 4.3 0.00 *190* HandFinish 0.00 Memo Hand Finishing Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch. 200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum *200* Powdercoat START TIME: Powder Coating OVEN TEMPERATURE: FINISH TIME:

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Hand Finishing

Item ID: D350-636-015 Accept *N900040100* Setup Start **Revision ID:** Skidtube STD w/ Training Wearplates, LH Item Name: *1* **Start Date:** 04/06/2012 Start Qty: 1.00 **Cust Item ID: Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop **QC**: **SPC (Y/N):** Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Stamp Number 210 QC3- Inspect Part Finish 0.00 *210* OC 0.00 Memo Quality Control Inspect for foreign object per QSI 024 220 0.00 HandFinishing 104 *220* HandFinish 0.00 Memo

1- Install inserts as per Dwg D4168

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Item ID: D350-636-015 Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube STD w/ Training Wearplates, LH 04/06/2012 **Start Date:** Start Qty: 1.00 **Cust Item ID: Required Date:** 18/06/2012 Rea'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: **Process Plan:** Date: Tooling: Date: Stop OC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Qty Code Number **Qty** Stamp 250 Pick Kit 0.00 *250* Packaging 0.00 Memo Packaging If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1 260 QC4-100% Inspect kits for completeness *260* Memo Quality Control ******ensure antiseize is on AN8C21A bolts****** Capp 20 270 0.00 Packaging *270* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPPD350-636-015

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D350-636-015 Item ID: Accept *N900040100* Setup Start **Revision ID:** Skidtube STD w/ Training Wearplates, LH Item Name: *1* **Start Date:** 04/06/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 18/06/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: QC: SPC (Y/N): Date: Date: Sequence ID/ **Operation** Set Up/ Accept Reject Tool ID Tool # Plan Reject Insp. **Work Center ID** Description **Run Hours** Qty Number Stamp Code Qty 280 QC21- Final Inspection - Work Order Release 0.00

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·Work Order ID: 85148

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Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP rev:A 10.09.28 new issue DD verf:EC

11.04.14 ecn11-553 DD verf:EC

IPP Rev:B IPP Rev:C 11.10.18 as per

NCR 11-906 DD verf:EC

IPP Rev:D 112.04.16 AS PER ECN 12-

542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
*AN3C34A BOLT		Purchased	No			230	Each	41.0000	**	1 *		
* - 25				Location ST353	116075 Wak	Loc	41 21	Loc Code		F		12/07/26
*AN3C36A *AN3C36A BOLT	/ *	Purchased	No		117514	230	20 Each	162.0000	4 **	⁴ Y		12/07/25

<u>Locatio</u> FG	15924~	Loc Oty 4 4	Loc Code	
ST353		158		
	116590	0		
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Work Order ID: 85148

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Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Purchased

Manufactured

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C37A *AN3C37A*

230 Each 141.0000 **

Location Loc Qty Loc Code 141 116874 11 117010 2 120422 3 121068 75 121585 50 AN3C42A Purchased No 230 Each 32.0000 *AN3C42A* **

No

Location Loc Qty ST354 32 106176 120464 6 25 230 Each

257.0000 **

Loc Code

D3492-1 Plug

D3492-1

Location	<u>1</u>	Loc Oty	Loc Code
FP002		242	
	69531	8	
	74444	2	
	76235	4	
	83259	228	
FP-A		15	
	83098	15	

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Work Order ID: 85148 *85148* D350-636-015 Parent Item: *D350-636-015* Parent Item Name: Skidtube STD w/ Training Wearplates, LH **Start Date:** 04/06/2012 **Required Date:** 18/06/2012 Required Qty: 1.00 Start Qty: 1.00 D3492-3 Manufactured 230 Each 167.0000 *D3492-3* (2/07/25 Location Loc Oty Loc Code 85461 FP-A 167 81967 5 83099 40 83529 122 D3873-1 Manufactured 230 Each 462.0000 *D3873-1* ** Bushing Location Loc Code Loc Qty ST057 79561 6 ST067 456 64760 68247 73829 19

D4154-041

Wearplate Assembly

D4154-041

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Each

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Manufactured

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12/07/25

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DATE	STEP	Section A	Initial Chief Eng			n & ate	& Section C		Chief Eng	QC Inspector
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		· -					-			
									,	

June-04-12 1:28:38 PM

Work Order ID: 85148

85148

Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4170-1

Manufactured

Manufactured

Purchased

No

230

Each

95.0000

D4170-1

Bushing

**

BE12/07/19

Location		Loc	<u>: Qty</u>	Loc Code				
LG			50					
	82222		50				4	
LG001			45					_
	71844		5					
	82043		40					_
		230	Each	22.0000		1	1	
					مادماد		_	,

D4171-1

D4171-1

Bushing

MS21043-3

3			
Location	<u>La</u>	oc Oty	Loc Code
ST104		22	
77008 82385		2	
82385		20	
	230	Each	1,557.000

1 00 12/07/25

MS21043-3

Location	Loc Oty	Loc Code	
FG	72		
103691	72		
GA	14		
120693	14		
ST301	1471		
118077	2		
118614	51		
118686	30		
119758	20		
121255	368		
121708	1000		

W/O:			V	VORK ORDER CHANGE	ES				,
DATE	STEP	PRO	CEDURE CI	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	; ;								
Part No: PAR #: Fault Category:			NCR: Yes	No DQ	A:	Date:			
	R	esolution:	Disposition: QA: N/C C						
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE STEP		Description of NC	Corrective Action Section B Initial Action Description			Sign & Section (Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
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Picklist Print

June-04-12 1:28:38 PM

Work Order ID: 85148

85148

D350-636-015

D350-636-015

Parent Item: Parent Item Name: Skidtube STD w/ Training Wearplates, LH **Start Date:** 04/06/2012 **Required Date: 18/06/2012** Start Qty: 1.00 Required Qty: 1.00 NAS1149C0363R Purchased No 230 Each 2.958.000 *NAS1149C0363R* ** Washer **Location** Loc Qty Loc Code ST297 2958 114742 2958 NAS1515H3L Purchased No 230 Each 146.0000 *NAS1515H31 * 12/07/25 ** Location Loc Qty Loc Code FG 122151 40 102472 40 ST277 106 118686 3 119438 120360 11 121243 2 89 121556 NAS1611-010 Purchased No 230 Each 188.0000 *NAS1611-010* ** O-RING Location Loc Qty Loc Code 122151 FP001 188 110915 14 117460 118077 118612 3 119438 47 121259 2 121415 4 121584 59 121723 50

_	1								
W/O:			W	ORK ORDER CHANG	ES				, , , , , , , , , , , , , , , , , , ,
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date: _	
	Resolution: Disposition:			on:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCI	₹)			
DATE	STEP	Description of NC						ion Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	& Secti	on C	Chief Eng	QC Inspector
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June-04-12 1:28:38 PM

Work Order ID: 85148

NAS1611-013

85148

Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each 361.0000

Location	Loc Qty	Loc Code	
FP001	361		
116582	5		
117291	2		
117887	53		
119623	36		
121584	15		
121825	200		
121826	50		
	2.50		_

Each

31

NAS1149D0863J

Purchased

No

250 251.0000 Each

**

Location Loc Qty Loc Code ST298 251 118078 34 119307 17 120308 100 121556 100

D2744

Manufactured

**

35.0000

D2744

Location Loc Qty Loc Code LG002 35 62715 78900 3

110

83412

W/O:			WORK ORDER CHANGES						
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
-									
Part No:PAR #: _		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _		
	Resolution: Disposition: QA: N/C Clo				osed:	Date: _			
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	ion B	Verification Section C	Approval Chief Eng	Approval QC inspector	
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC inspector	
		•		A fraction pro- species -					
···									
						·			

June-04-12 1:28:38 PM

Work Order ID: 85148

85148

Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

110

Start Qty: 1.00

Required Qty: 1.00

B86330 ×1

D2600-3-BENT

Manufactured

Each 29.0000

**

D2600-3-BENT

Extrusion Bent

Location	<u>Lo</u>	e Oty	Loc Code		
LG		29			
66875		7			
73253		1			
75021		1			
75022		1			
75023		1			
81330		4			
83305		1			
83442		13			
	160	Each	296.0000	8	8

D2743

Crossbolt Spacer

Manufactured

**

BE12/07/19

Location	Loc Qty	Loc Code	
LG	222		
81965	55		
83262	167		8
LG001	74		
67766	4		
68251	3		
73403	64		
74445	1		
79517	2		

W/O:		WORK ORDER CHANGES								•
DATE	STEP	PRO	HANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval •QC Inspector	
	,								·	·
									<u> </u>	
Part No	:	PAR #:	Fault Category: No			CR: Yes No DQA: Date: _				
					A: N/C Closed: Date:					
NCR:			NORK OR	DER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC Section A	Corrective Action Section E Initial Action Description			gn &	Verification		Approval	Approval
			Chief Eng	Chief Eng		Date	Section C		Chief Eng	QC Inspector
					χ'					
•										
							:			

June-04-12 1:28:38 PM

Work Order ID: 85148

85148

Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Manufactured

Manufactured

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

D2739

350 1 Beam

Manufactured 160 Each 13.0000

**

CE 121-17

<u>Location</u>	<u>Lo</u>	c Qty	Loc Code			
LG		13				
72155		1				
81508		1				
83447		4				
83448		5				
83548		2				
	160	Each	46.0000	4	4	
			*	*		

D3490-3

D3490-3

Cross Bolt Spacer

Location	<u>Lo</u>	e Qty	Loc Code			
LG001		46				
83313		46				
	160	Each	45.0000	4	4	
				L-		

D3490-1

Cross Bolt Spacer

Location	Loc Qty	Loc Code	
LG	2		
81976	2		
LG001	43		
62450	2		
74875	4		
77042	3		
83269	34		

W/O:			WC	RK ORDER CHAN	IGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date Qty Chie		Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	jory:	NCF	R: Yes	No DQA	٨:	_ Date: _	
	R	esolution:	Disposition: QA:			QA: N/C Closed: Date:				
NCR:			WORK ORDE	ER NON-CONFORM	WANCE	(NCR)			
DATE	STEP	Description of NC			ection B	Verification			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	n.	Sign & Date	Section	on C	Chief Eng	QC Inspector
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	,									
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June-04-12 1:28:38 PM

Work Order ID: 85148 *85148* *D350-636-015* Parent Item: D350-636-015 Parent Item Name: Skidtube STD w/ Training Wearplates, LH **Required Date: 18/06/2012 Start Date:** 04/06/2012 Required Qty: 1.00 Start Qty: 1.00 ALS4-1032-225 Purchased No 230 Each 781.0000 *AI S4-1032-225* ** 12/07/25 Location Loc Qty Loc Code ST281 758 108696 146 110768 62 118386 55 118966 68 121269 427 ST282 23 120410 10 120451 13 AN8C35A Purchased No 230 Each 68.0000 *AN8C35A* 12/07/25 **

No

Manufactured

Location	Loc	: Oty	Loc Code	:			
FP002		67					
115960		1					
118286		16					
121275		50					
ST346		1					
114442		0					
115188		0					
115960		1					
	230	Each	9.0000	1	1		
				**	1		[2/07/25

Blade Fitting Assembly, LH

D3488-041

Locatio		Loc Qty	Loc Code	
FP002	857331	9		
	61689	1		
	82271	8		

W/O:		WORK ORDER CHANGES						• , , ,
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / . Prod Mgr	Approval QC inspector
				7				
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes I	No DQA:	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C Cld	sed:	Date: _	
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval
DALL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
As								
					·			:

June-04-12 1:28:38 PM

Work Order ID: 85148

85148

Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

**

Required Qty: 1.00

AN6C44A

Purchased

Purchased

No

230

86.0000 Each

Loc Code

12/07/25

AN6C44A **BOLT**

Loc
FG
ST3

No

cation Loc Qty 122204~ 2 103964 2 343 84 121013 11 121167 13 121440 50 121689 10 230 Each

81.0000 **

MS21083C8

NUT

MS21083C8

<u>Locatio</u>	<u>ın</u>	Loc Qty	Loc Code	
304		75		
	121185	29		
	121349	46		
FP002		1		
	115884	1		
ST303		4		
	115884	0		
	118077	1		
	119309	2		
	119638	1		
ST304		1		
	121524	1		
ST304	119638	2 1 ! 1		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvat QC Inspector	
		Marie de la companya							
						,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	· · · · · · · · · · · · · · · · · · ·
	Re	esolution:	Disposition: QA: N/C			Closed: Date:			
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval	Approval
	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
_									
								-	

June-04-12 1:28:38 PM

Work Order ID: 85148 Parent Item: D350-636-015

D3631-1

85148 *D350-636-015*

Location

81874

68062

75548

122063

83588

FG

ST072

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Washer

Manufactured

230 Each

Loc Qty

332

330

15

2

13

Each

2

347.0000 **

Loc Code

0.0000

8

12/07/25

AN960C10L No

NAS1149C0332 Purchased

*AN960C101 *

washer D2745

Manufactured

230 Each

230

122,0000

**

**

**

D2745

Bushing

<u>Locatio</u>	<u>n</u>	Lo	e Qty	Loc Code		
FP			6			
	79518		6			
FP001			116			
	69529		ı			
	76142		1			
	83260		114			
	85416	230	Each	257.0000	1	1

NAS1149C0832R

Purchased No

NAS1149C0832R

WASHER

<u>Location</u>	Loc Qty	Loc Code
ST297	257	
114915	257	

_									•	
W/O:			WC	RK ORDER CHANG	ES				• •	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	By Date Qty Approval Chief Eng / Prod Mgr			Approvat •QC Inspector	
							-,, -, -, -, -, -, -, -, -, -, -, -, 			
		PAR #:	Fault Categ	jory:	_ NCR: Yes I	No DQA	۷:			
	Re	solution:	Disposition):	_ QA: N/C Clo	osed: Date:				
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCR))				
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation		Approval	
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector	
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June-04-12 1:28:39 PM

Work Order ID: 85148

85148

No

Parent Item:

D350-636-015

D350-636-015

230

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Purchased

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

AN3C6A

Each 451.0000 **

Location	<u>L</u>	oc Qty	Loc Code		
FP001		1			
111982		1			
ST351		450			
111982		2			
116419		23			
116549		2			
116704		12			
117619		10			
117688		1			
117872		5			
118422		13			
119449		21			
120423		3			
120693		158			
121682		200			
	230	Each	618.0000	4	4

MS21043-6

Purchased No

12/07/25

MS21043-6 NUT

Locatio	<u>n</u>	Loc Qty	Loc Code	
FG		20		
	103693	20		
ST301		598		
	117887	2		
	118384	96		
	120308	500		

		— - -									
W/O:		** table	WC	RK ORDER CHAN	GES				• •		
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Qty Approval Chief Eng / Prod Mgr			
Part No: PAR #			Fault Cated	jory:	NCR: Ye	s No D	QA:	_ Date: _			
	Res	solution:	Disposition	l:	QA: N/C	Closed: _	ed: Date:				
NCR:		,	WORK ORDE	ER NON-CONFORM	IANCE (NO	R)					
DATE	STEP	Description of NC			ction B		fication	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		ection C	Chief Eng	QC Inspector		
		244									
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					·						

June-04-12 1:28:39 PM

Work Order ID: 85148

85148

Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

MS21083C8

Manufactured

Purchased

Purchased

No

250

Each 127.0000

Loc Code

81.0000

**

D3493-1

	Location	<u>L</u>	oc Qty
	ST050		127
	77573		1
	82023		26
	83097		100
No		250	Each

S21083C8*

Location	Loc Qty	Loc Code
304	75	
121185	29	
121349	46	
FP002	1	
115884	1	
ST303	4	
115884	0	
118077	1	
119309	2	

119638 ST304 121524

57.0000

**

AN8C21A

Location	Loc Qty	Loc Code
ST343	57	
118758	3	
121167	4	
121275	50	

250

Each

June-04-12 1:28:39 PM

Shop Packet Print

Page 13

W/O:		- • 	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Da	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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							,		
		:							
		PAR #:	Fault Cat	egory:	_ NCR: Ye	s No	DQA:	_ Date: _	·
	Re	esolution:						Date: _	
NCR:		\	WORK ORE	DER NON-CONFORMA	NCE (NO	CR)			
DATE	STEP Description of NC			Corrective Action Section		v	erification	Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da		Section C	Chief Eng	QC Inspector
**				•					
				ı					

June-04-12 1:28:39 PM

Work Order ID: 85148

85148

Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured

250

Each 20.0000

**

Location Loc Qty Loc Code ST -10 ST466 30 71856 79516 19

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA		Ву	By Date Qty Approval Chief Eng / Prod Mgr			Approval QC Inspector
			· · · · · · · · · · · · · · · · · · ·						:
Part No.		DAD #.	Foult Coto	gon.	NCP: Yes	No DO	<u> </u>	Dotos	
rait NO		PAR #: esolution:							
	יח			ER NON-CONFORM			·	Date:	· · · · · · · · · · · · · · · · · · ·
NCR:	1					·)			
DATE	STEP	Description of NC Section A	Initial	ion B Sign &		erification Section C	Approval Chief Eng	Approval QC Inspector	
-		Section A	Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC inspector
							,		

	QTY -041	QTY -042	QTY -043	QTY -044		DESCRIPTION
•	Х				D4168-041	350 SKIDTUBE ASSEMBLY, LH
		X	I		D4168-042	350 SKIDTUBE ASSEMBLY, RH
	L	L	X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
		T		X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
D	1	1	1 1	1	D2739	WEB
	- 8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1		1		D3488-041	BLADE FITTING, LH
		1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
_			4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
ŀ	8	- 8			D3492-043	PLUG ASSEMBLY
			_ 8	8	D3492-045	PLUG ASSEMBLY
	8	8	8	8	D3631-1	WASHER
- 1	7	7	_ 7	7	D3873-1	BUSHING
	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
	1				D4168-1	SKIDTUBE WELDMENT, LH
2		1			D4168-2	SKIDTUBE WELDMENT, RH
			_ 1		D4168-3	SKIDTUBE WELDMENT, LH
ı				1	D4168-4	SKIDTUBE WELDMENT, RH
Į	4	4	4	4	D4170-1	SPACER
ı	11	1	1	1	D4171-1	BUSHING
- !						
Į	4	4	4	4	ALS4-1032-225	INSERT
L	4	4	4	_4	AN3C6A	BOLT
4	1	1	1	1	AN3C34A	BOLT
	4	4	4	4	AN3C36A	BOLT
L	4	4	4	4	AN6C44A	BOLT
L	1	1	1	1	AN8C35A	BOLT
L	9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
	.4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
Ĺ	1	_1	1		AN960C816L	WASHER (OR NAS1149CO832R)
L	5	5	5	5	MS21043-3	NUT
Ļ	4	4	4		MS21043-6	NUT
L	1	1	1		MS21083C8	NUT
L	4	4	4	4	NAS1515H3L	WASHER

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 85148 MLJ 12/06/04

GENERAL NOTES:

MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

MATERIAL: MARE D4 108-17-21-31-4 PROM D2500-3 EXTROSION (INTITAL LENGTH = 120.0).

FINISH:

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS

WELD PER DART QSI 004

FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 35 KSI

MINIMUM YIELD TENSILE STRENGTH = 38 KSI

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

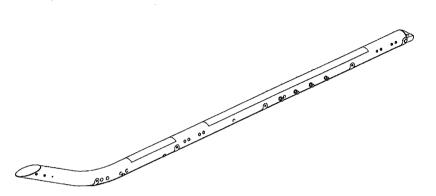
DELEASE 2010 -09- 15

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DESIGN SC		DART AEROSPACE USA, INC.						
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MFG. APPR.	-Al	D4168		SHEET 1 OF 1				
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DE APPR.	#-	350 SKIDTUBE ASSEMBLY NT						
DATE 10.0	08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT OF PRIVATE AND CONTRIBUTING, AND IS SUPPLIED ON THE COPYRESS CONCRIGHD THAT IT IS NOT TO SE VISED FOR ANY PURPOSE ON CONSIDERATION THAT OF THE PRIVATE OF THE						

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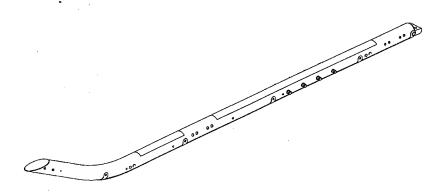
D4168-041 350 SKIDTUBE ASSEMBLY, LH

D4168-042 350 SKIDTUBE ASSEMBLY, RH

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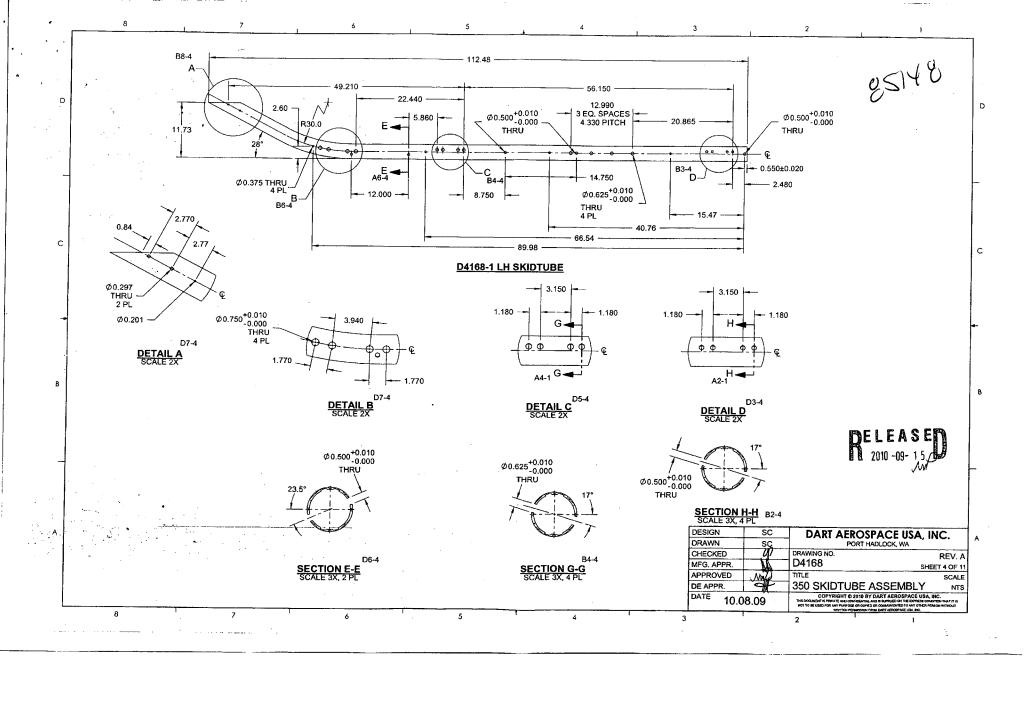
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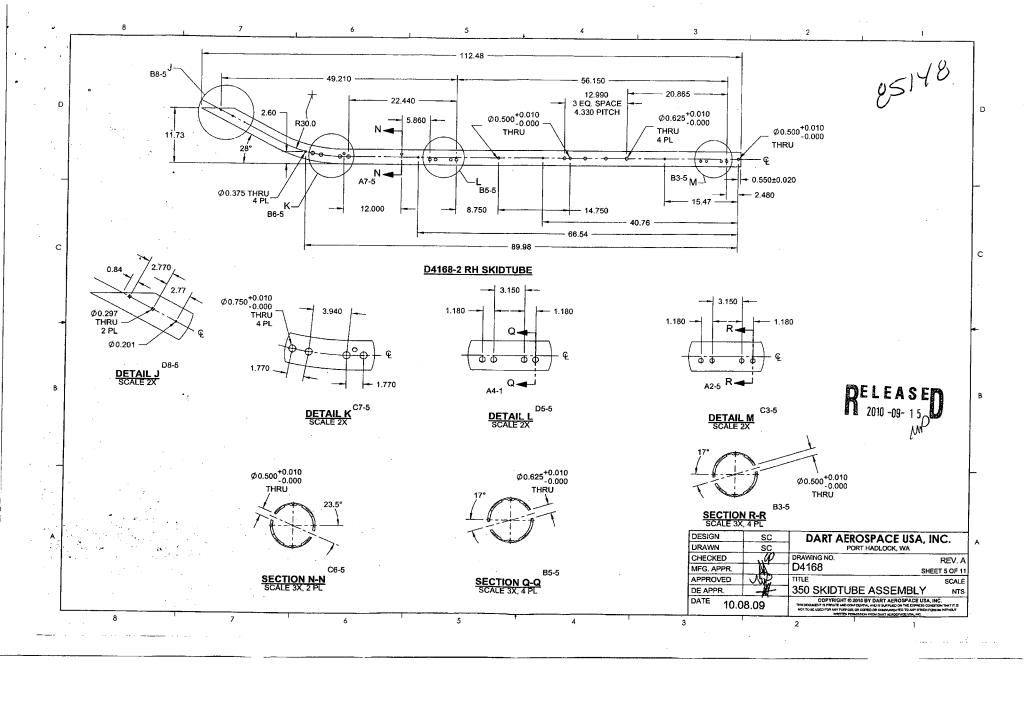
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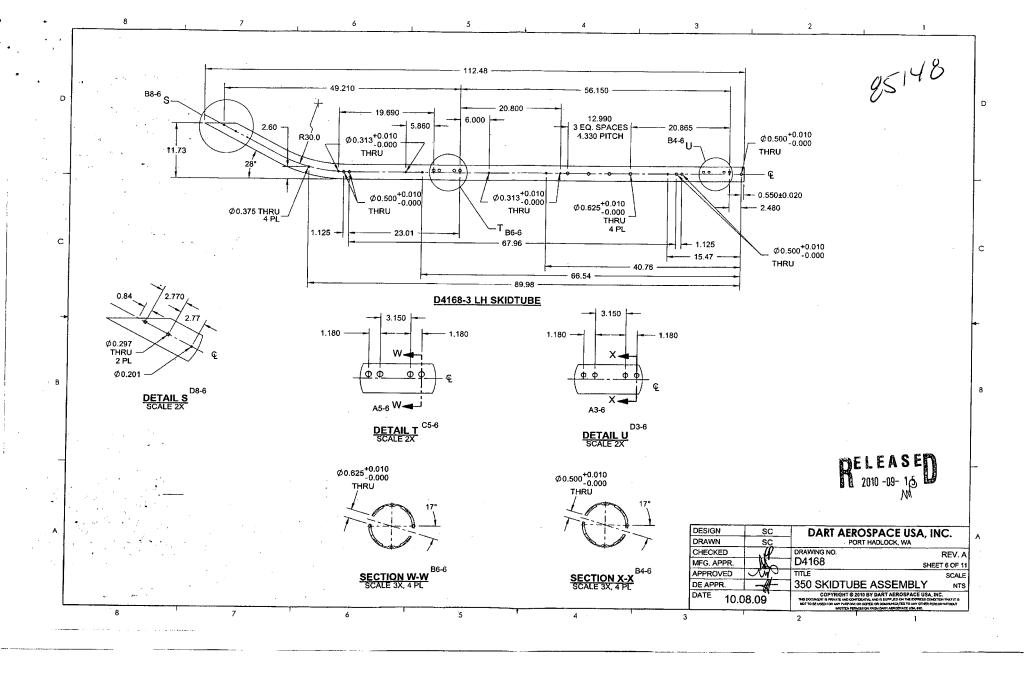
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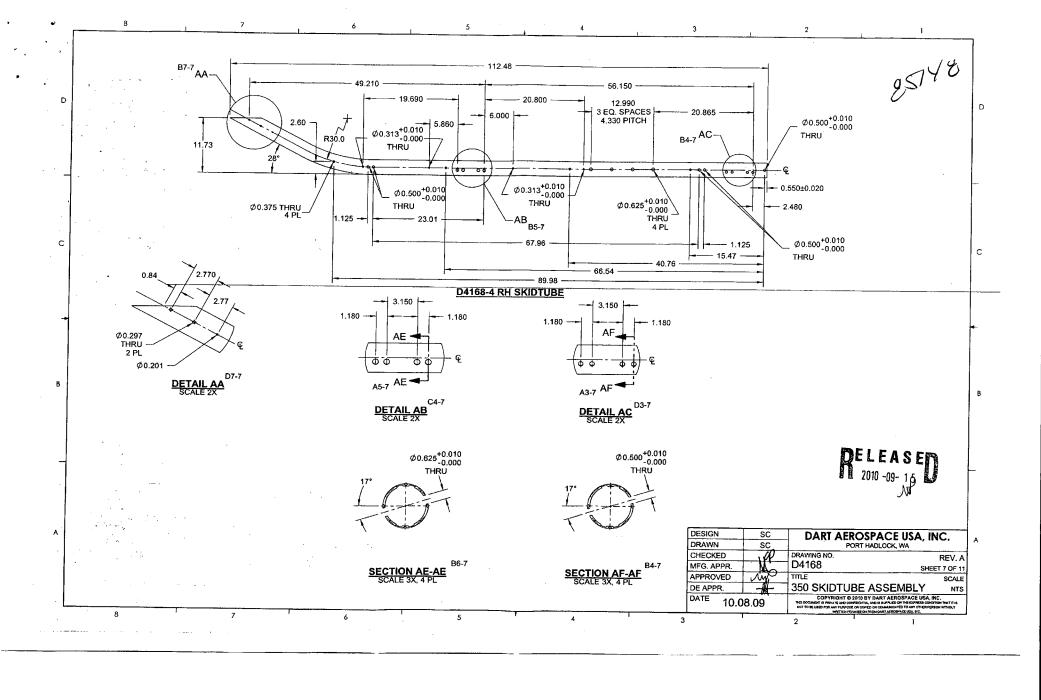
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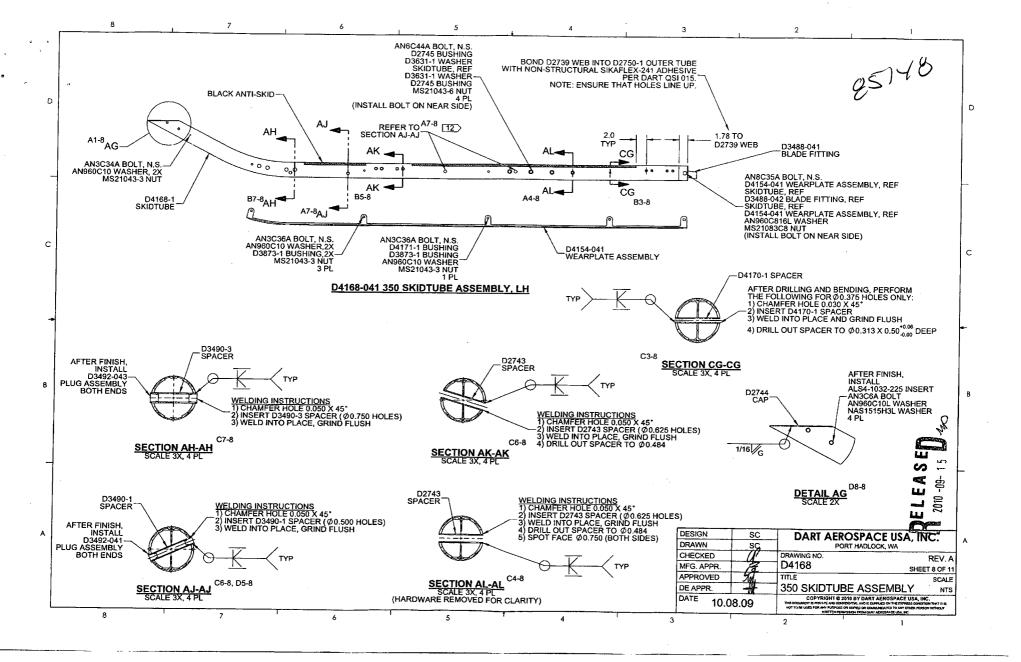
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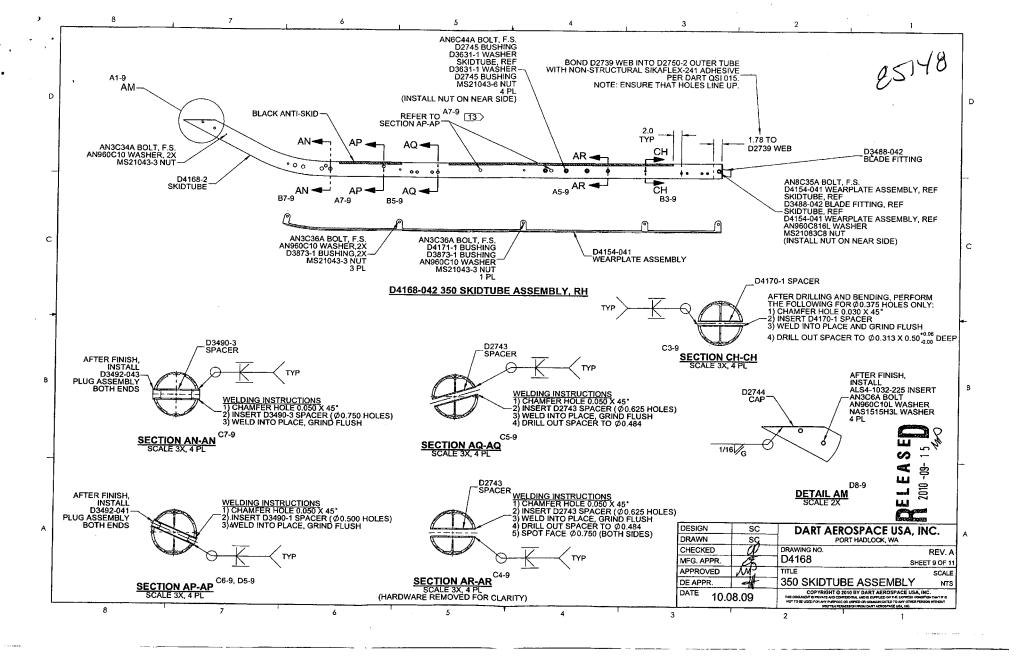


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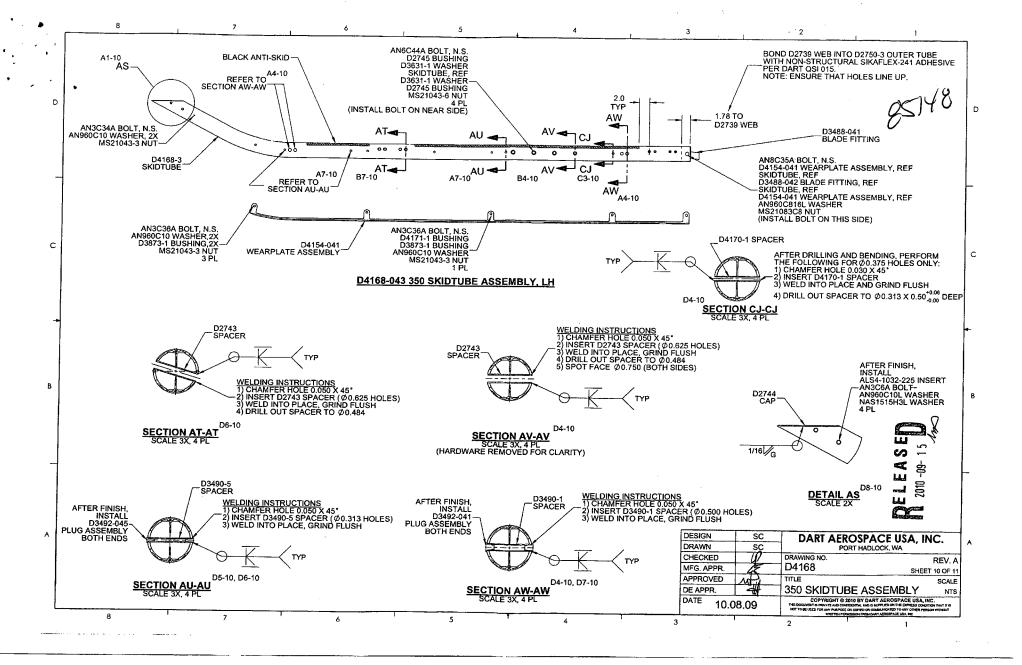
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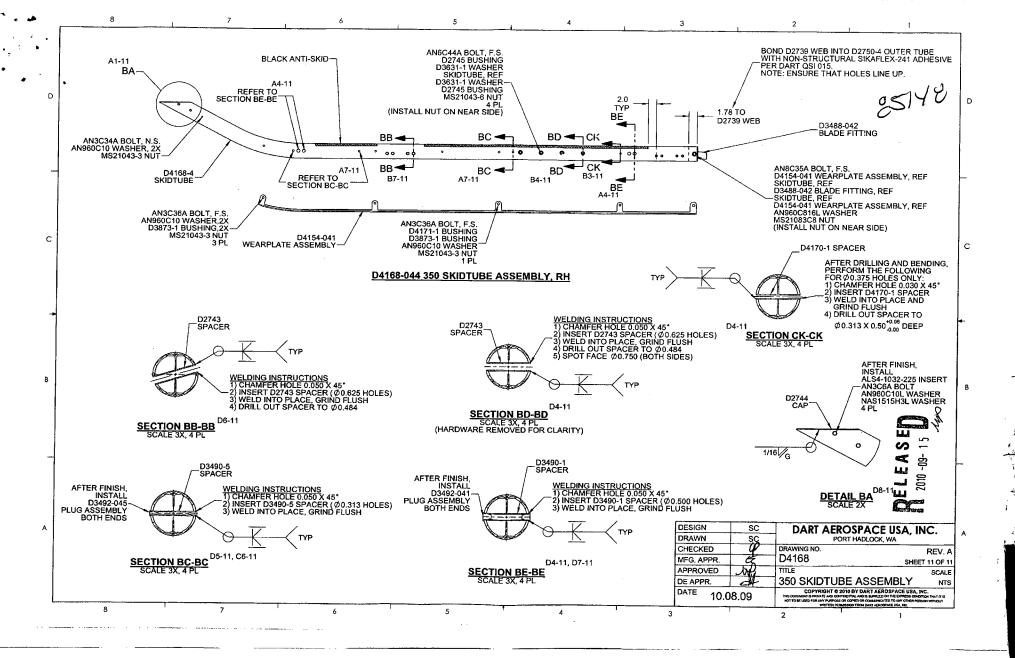
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NO. 298

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Borelay Elliott	
Job #: 87012	
Part #: <u>1350-636-614</u>	-
Description: Skid tulse	
Welding Process: Tig[-] Mig[]	-
Base materiel: Alun hun-	
Current: AC[\rightarrow DC[]	

TEST REQUIREMENTS AND RESULTS

Visual:	pass[-	fail[]
Incomplete Penetration:	pass[]	fail[]
Incomplete Fusion:	pass[/	fail[]
Cracks:	pass[]	fail[]
Overlap (cold lap)	pass[-}-	fail[]
Undercut:	pass[-]	fail[]
Pin holes:	pass[]	fail[]
Porosity (surface):	pass[]	fail[]
Coloration:	pass[]	fail[]
Burn through:	pass[+	fail[]

Qualifier Date of Test Coupon 2.07.23

Welder Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld